Work Order ID 97253

97253

February-14-13 1:23:20 PM

Item ID: D119-696-043 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Dual Cargo Mirror Assy. 6 inch Round

Start Date: 2/13/13 **Start Qty:** 2.00 *2*

Required Date: 2/26/13 **Req'd Qty:** 2.00 *2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 13-02-15 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D4450	A
IIN-D119-696	A

100 0.00

100

Small Fab — Small Fab

Memo 0.00

1- punch one side
2- slide parts in tube
3- punch other side
4- bend as per dwg (TOOLING)
5- drill holes as per dwg
6- deburr and polish

2 ø FF 13-02-07

BTO

110 QC5- Inspect part completeness to step on W/O 0.00

110

QC — Quality Control

Memo 0.00

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: [signature] Date: 13/9/13

QA Closed: [signature] Date: 13/9/13

Work Order: 97253

Part No. D119-696-043

NCR No. 13-3071

DISPOSITION

Rework ☐
Scrap ☒
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☒ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐	13.8.8	100	2	part scrap use wrong tooling to bend part	DAS 16 9-89	Destroyed and replaced with P# 126466	13-09-18 FF	DAS 16 9-89	DAS 16 9-89
Equip/Tooling	☒									
Operator	☒									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐				RC operator error didn't pay attention					
Unapproved	☐									

Q>2cu2 13/09/18

replace bolt 121556 FF
replace washer 124392 FF
replace nut 126036 FF
583.30

13/09/18

13/09/18

10 Days / Injury templates in PROD AREA.

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☒ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 97253

97253

February-14-13 1:23:20 PM

Item ID: D119-696-043 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Dual Cargo Mirror Assy, 6 inch Round

Start Date: 2/13/13 **Start Qty:** 2.00 *2*

Required Date: 2/26/13 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Small Fab	0.00							
120 Small Fab						2	0		13-09-13
Small Fab	**Memo** Assemble as per dwg	0.00							
130	QC5- Inspect part completeness to step on W/O	0.00							
130 QC						(2)			
Quality Control	**Memo**	0.00							DAS 16 9-89 13/09/13
140	Identify as per dwg & Stock Location:____	0.00							
140 Packaging						2			13/3/13 DAS 32 9-89
Packaging	**Memo** PPP 97230	0.00							

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 97253

February-14-13 1:23:20 PM

97253

Item ID: D119-696-043 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Dual Cargo Mirror Assy, 6 inch Round

Start Date: 2/13/13 **Start Qty:** 2.00 *2*

Required Date: 2/26/13 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	**Memo**	0.00							
Quality Control									

13/9/20

MF 13-9-19

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

February-14-13 10:54:53 AM

3

Work Order ID: 97253

Parent Item: D119-696-043 **Start Date:** 2/13/13 **Required Date:** 2/26/13

Parent Item Name: Dual Cargo Mirror Assy, 6 inch Round **Start Qty:** 2.00 **Required Qty:** 2.00

Comments: IPP Rev:A 08-02-19 New issue DD verified by: LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 Washer	NAS1149D0363J	Purchased	No	124392		100	Each	0.0000	6	12 12	FF	13-08-07	
D2011-101 6" Mirror		Manufactured	No			100	Each	43.0000	2	4	FF	13-08-07	
				Location 100741		**Loc Qty**		**Loc Code**		4			
				ST229		43							
				86647		1							
				89784		42							
D2054 Bushing		Manufactured	No			100	Each	53.0000	2	4	FF	13-08-07	
				Location		**Loc Qty**		**Loc Code**					
				GA		53							
				85864		14							
				87318		13				4			
				93250		26							
D2055 Clamp		Manufactured	No			100	Each	37.0000	2	4	FF	13-08-07	
				Location		**Loc Qty**		**Loc Code**					
				GA		37							
				77110		1							
				85942		18				4			
				92691		10							
				95397		8							
D2056 Bell Crank		Manufactured	No			100	Each	23.0000	1	2	FF	13-08-07	
				Location		**Loc Qty**		**Loc Code**					
				GA		23							
				85943		11				2			
				92742		12							

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

February-14-13 10:54:54 AM

Work Order ID: 97253

Parent Item: D119-696-043 **Start Date:** 2/13/13 **Required Date:** 2/26/13

Parent Item Name: Dual Cargo Mirror Assy, 6 inch Round **Start Qty:** 2.00 **Required Qty:** 2.00

D3072-1 Bracket	Manufactured	No	96791	100	Each	7.0000	1	2 2 FF FF 13-08-07

Location	Loc Qty	Loc Code	
ST025	7		
57252	2		
96791	5		

D3072-2 Bracket	Manufactured	No	97268	100	Each	0.0000	1	2 2 FF 13-08-07
M304TR0.500W.049 304 RD Tube .500 x .049W	Purchased	No		100	f	386.1843	3.49	7.3473684 FF 13-08-07

Location	Loc Qty	Loc Code	
126466			3.6073 ?
GA 125513	62		3.673
120633	62		
MAT017	324.184316		
111814	4.46		
115010	140.814316		
117598	1.5		
119087	14.718		
123449	162.692		

MS21042L3 Nut	Purchased	No		100	Each	7,210.0000	3	6 FF 13-08-07

Location	Loc Qty	Loc Code	
FP001 126036	3		6
122141	3		
GA	414		
122452	414		
ST314	268		
117885	32		
119017	55		
119075	138		
123265	43		
ST506	6525		
123900	2525		
124291	4000		

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
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- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

February-14-13 10:54:54 AM

Work Order ID: 97253

Parent Item: D119-696-043

Parent Item Name: Dual Cargo Mirror Assy, 6 inch Round

Start Date: 2/13/13 **Required Date:** 2/26/13

Start Qty: 2.00 **Required Qty:** 2.00

MS27039-1-18	Purchased	No	100	Each	2,020.0000	**3**	**6**	FF 13-08-07
Screw								

Location		Loc Qty	Loc Code	
ST306		22		
	120308	2		
	121556	20		6
ST516		1998		
	124326	1998		

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

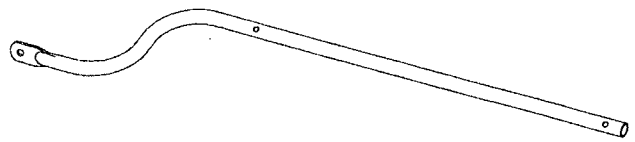
FAULT CATEGORY

Landing Gear

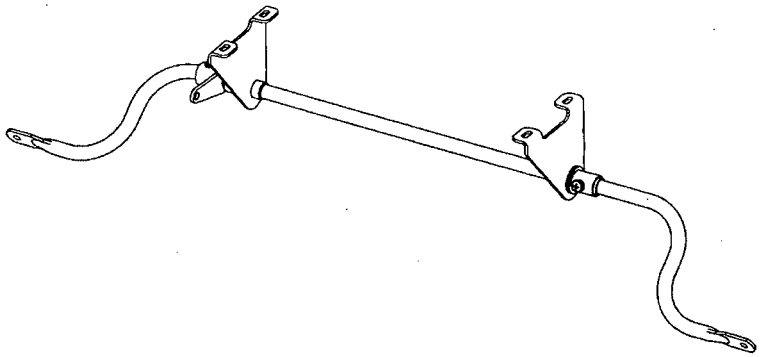
- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
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- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____



D4450-1 ARM



D4450-043 ARM

ENGINEERING
UNCONTROLLED COPY
97253 MLS
13-02-15

RELEASED
2011-11-10

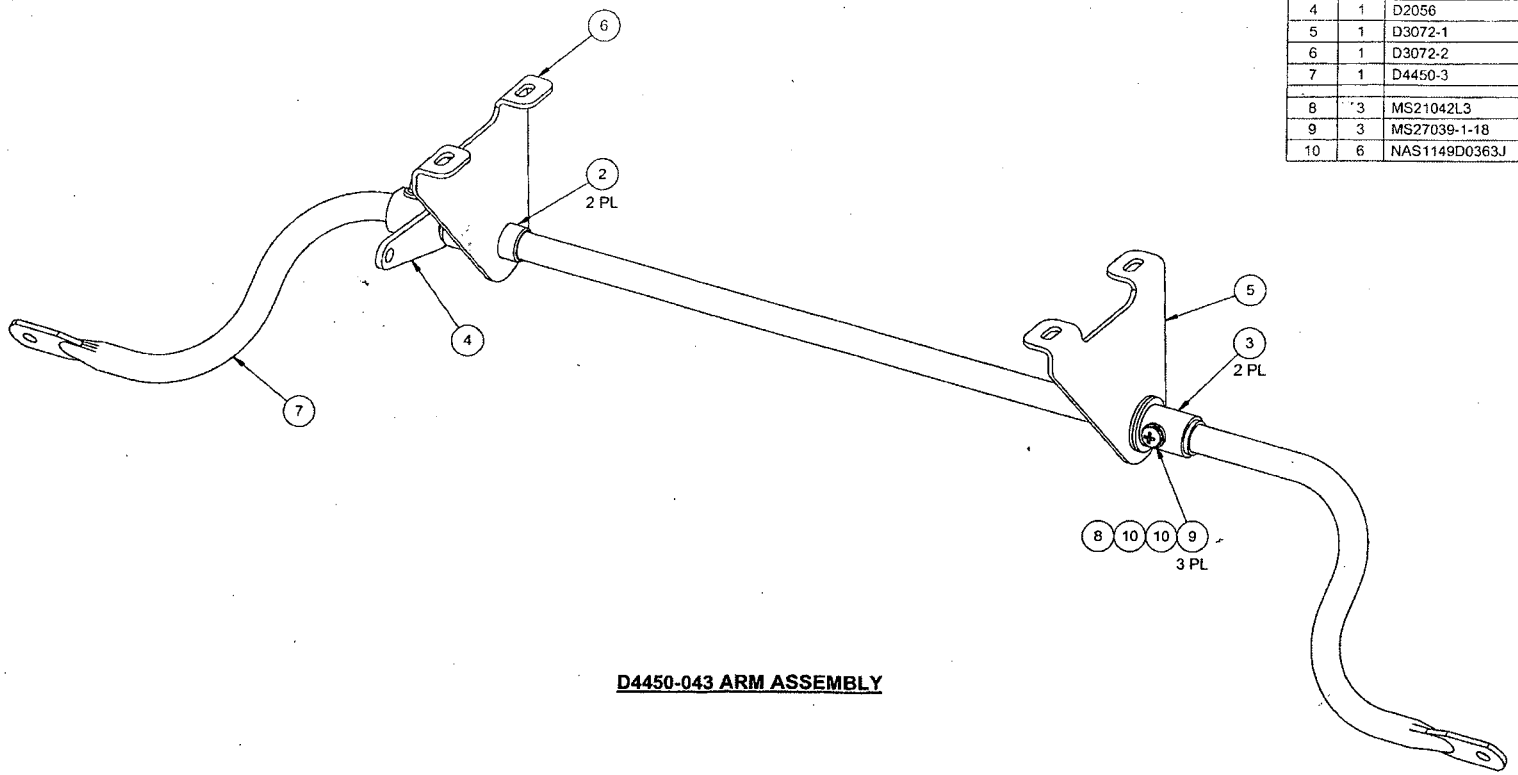
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	11.09.29

DESIGN	DART AEROSPACE USA, INC. KENT, WA
DRAWN	
CHECKED	DRAWING NO. REV. A
MFG. APPR.	D4450 SHEET 1 OF 4
APPROVED	TITLE SCALE
DE APPR.	ARM NTS
DATE 11.09.29	

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97253

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4450-043	ARM ASSEMBLY
2	2	D2054	BUSHING
3	2	D2055	CLAMP
4	1	D2056	BELLCRANK
5	1	D3072-1	BRACKET
6	1	D3072-2	BRACKET
7	1	D4450-3	ARM
8	3	MS21042L3	NUT
9	3	MS27039-1-18	SCREW
10	6	NAS1149D0363J	WASHER



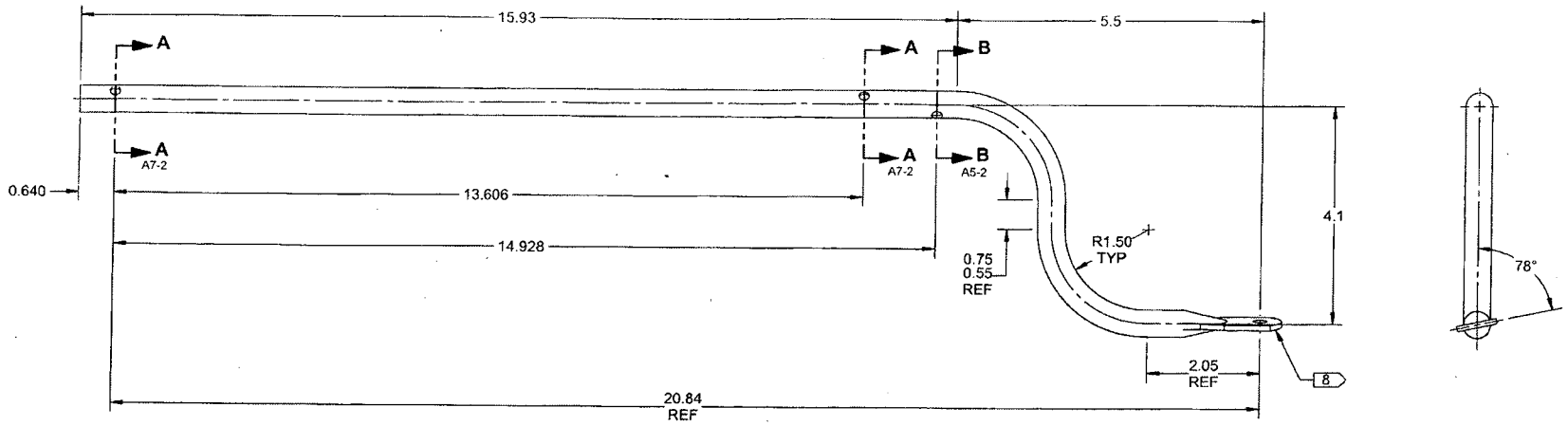
D4450-043 ARM ASSEMBLY

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2011-11-16

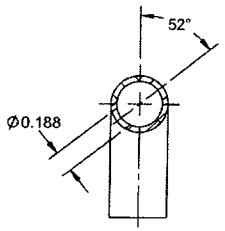
DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D4450 REV. A
MFG. APPR.		SHEET 2 OF 4
APPROVED		TITLE ARM SCALE NTS
DE APPR.		
DATE 11.09.29		

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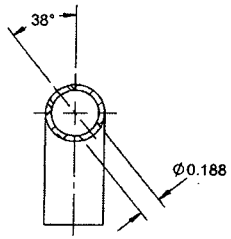
97253



D4450-1 ARM



SECTION A-A C4-2 C8-2
SCALE 2X



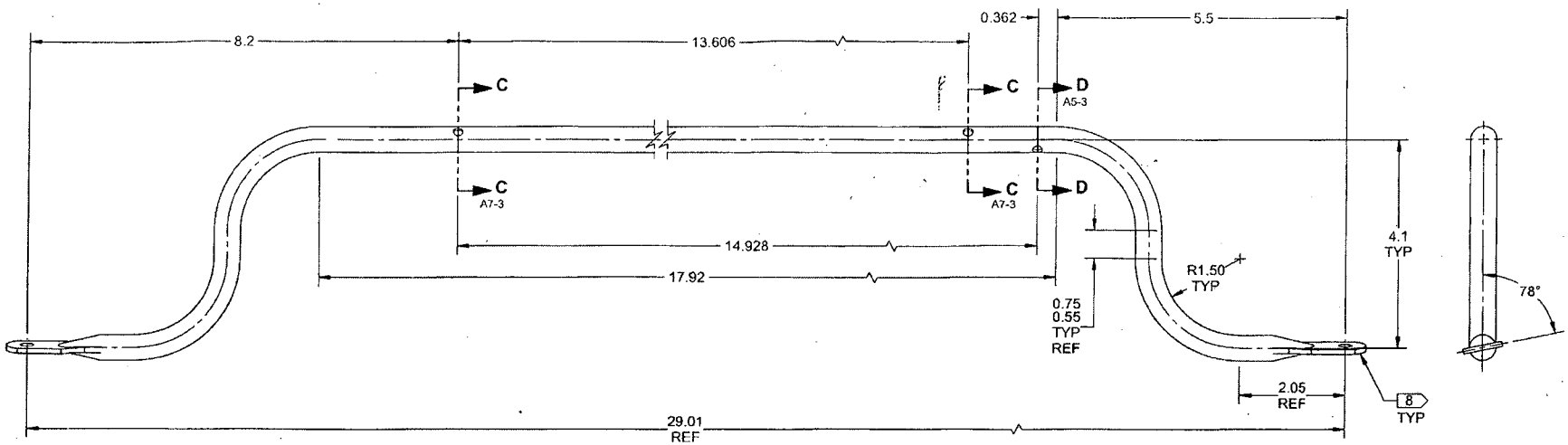
SECTION B-B C4-2
SCALE 2X

RELEASED
2011-11-10

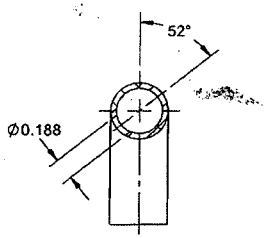
D4450-1 NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, Ø0.50 X 0.049 WALL
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF. DART SPEC. M304TR0.500W.049
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.49 lbs
8) PUNCH END PER SPEC. CONTROL DRAWING D2727

DESIGN		DART AEROSPACE USA, INC. KENT, WA
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CHECKED		DRAWING NO. D4450 REV. A
MFG. APPR.		SHEET 3 OF 4
APPROVED		TITLE ARM SCALE NTS
DE APPR.		
DATE 11.09.29		

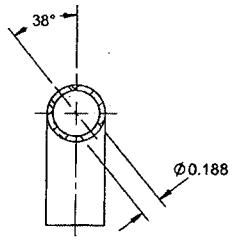
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D4450-3 ARM



SECTION C-C C4-3 C6-3
SCALE 2X



SECTION D-D D3-3
SCALE 2X

RELEASED
2011-11-10

D4450-3 NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, Ø0.50 X 0.049 WALL
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF. DART SPEC. M304TR0.500W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION NONE
7) WEIGHT: 0.72 lbs
8) PUNCH END PER SPEC. CONTROL DRAWING D2727
9) REFER TO SHEET 2, D4450-043 ARM ASSEMBLY, FOR INSTALLATION OF REQUIRED PARTS PRIOR TO PERFORMING ALL BENDS

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D4450 — REV. A — SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE ARM — SCALE NTS
DE APPR.		
DATE 11.09.29		

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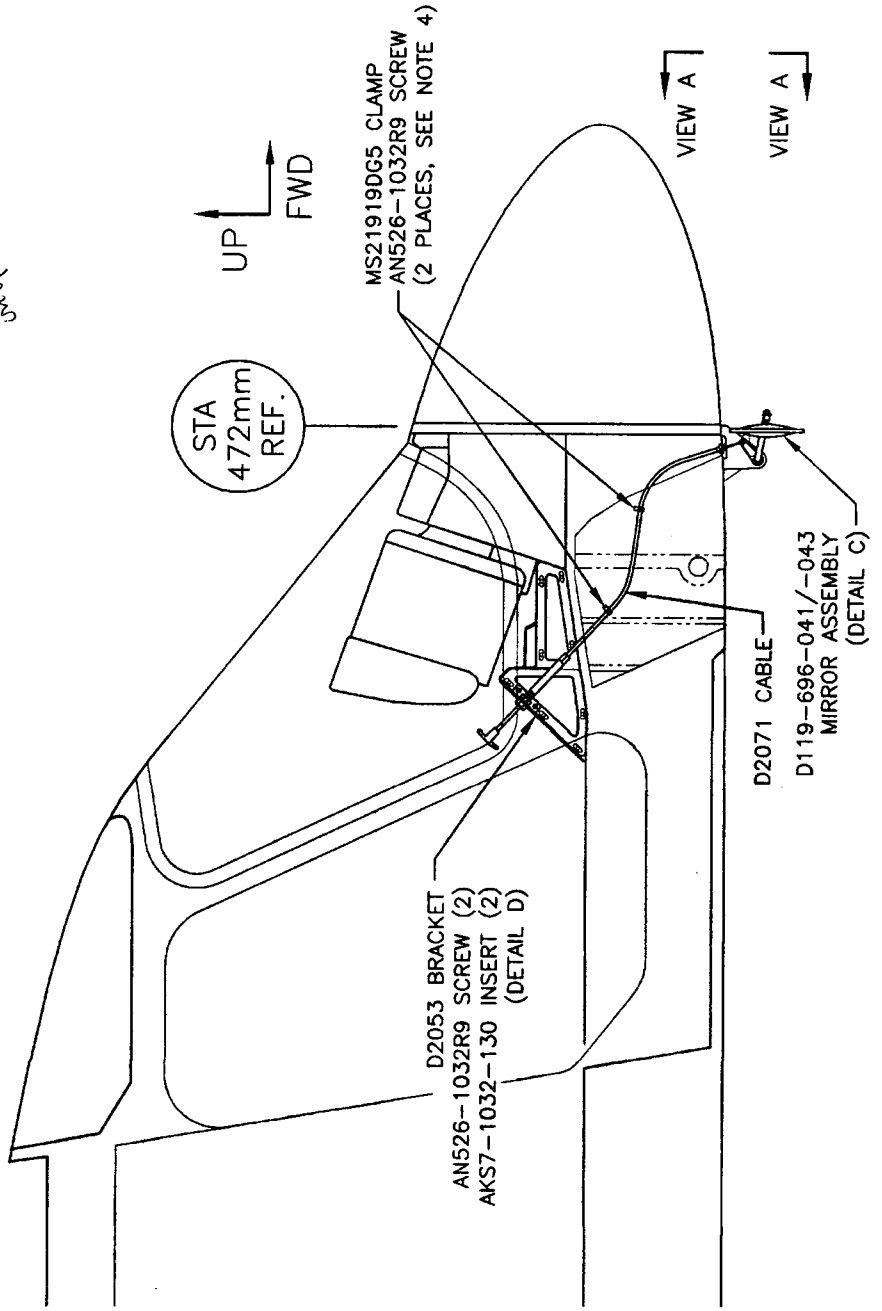


***Figure 25-1** – Dart D119-696-011/-013 Cargo Mirror Installation (shown in deployed position)*

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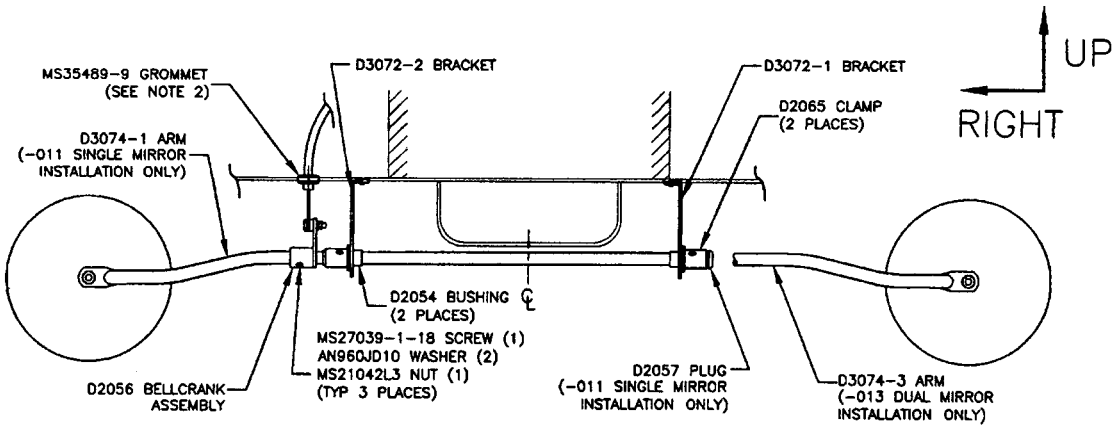


***Figure 25-2** – View A: Looking Aft*
(D119-696-011/-013 Mirror Shown)

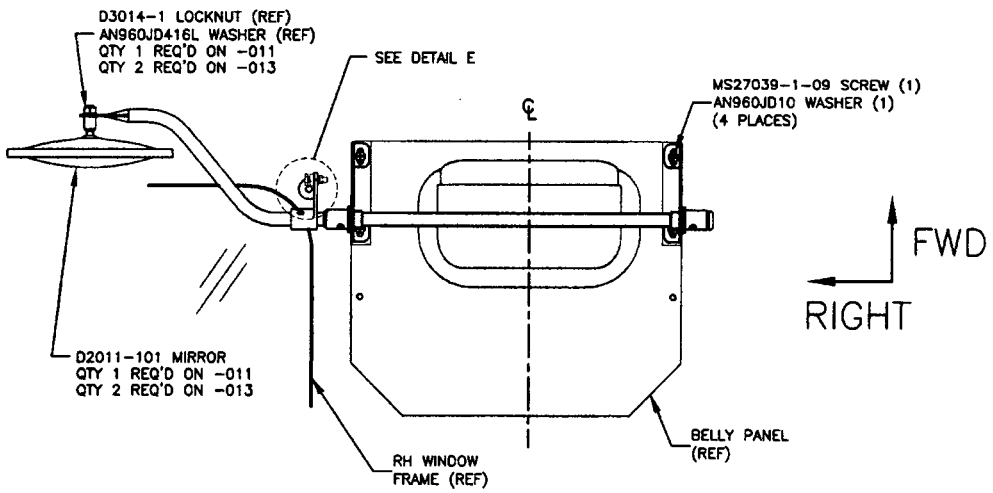


***Figure 25-3** – View B: Looking Up*
(D119-696-011 Mirror Shown, -013 similar)

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